

Tuesday, May 09, 2017 12:59:18 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

②
2
2

DAS
21
9-89

Start Date: 4/10/2017 **Start Qty:** 2.00

Cust Item ID:

Required Date: 4/17/2017 **Req'd Qty:** 2.00

Customer:

Reference: SCHEDULED/S

Approvals: Process Plan:  Date: MAY 09 2017

Tooling:

Date: _____

Run Start *NR1*

QC: _____

Date: _____ **SPC (Y/N):** _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3943

E

100

Weld per dwg A/R S.S. rod Batch: M136585 0.00

100

Large Fab

Memo

1.32

Large Fab

ASSEMBLE WITH CHAIN BEFORE WELDING

110

QC9- Inspect visual per QSI004- Fusion Welds	0.00
--	------

110

QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O	0.00
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120

QC

Memo

0.04

Quality Control

② _____ DYC _____
17/09/06

③ 17-09-06

(2) 17.04.20

Work Order ID 158970

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158970

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Item ID: D3943-053 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chain Assembly
Start Date: 4/10/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/17/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Hybrid safety Yellow 4.3.5.12 Memo <i>M. 1/16 329.</i> 1- MASK CHAIN FROM THIS POINT ON PRIOR TO powdercoat AS PER DWG 2- POWDER COAT: Start Time: <i>9:00</i> Oven Temperature: <i>320°</i> Finish Time: <i>9:30</i>	0.00 0.28				<u>2</u>	<u>0</u>	<u>17-09-8.</u>	<i>DAS 94 9-89</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02			<i>DAS 30 9-89</i>	<u>2</u>			<i>17/09/11</i>
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>8F</i> Memo <i>WA002</i>	0.00 0.02				<u>2</u>		<u>SEP 21 2017</u>	<i>DAS 6 9-89</i>

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Item ID: D3943-053 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chain Assembly
Start Date: 4/10/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/17/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

SEP 21 2007

Picklist Print

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Work Order ID: 158970

158970

Parent Item: D3943-053

D3943-053

Parent Item Name: Chain Assembly

Start Date: 4/10/2017

Required Date: 4/17/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: add DEO DD 09.11.18 verified by:JLM IPP Rev:B as
per dwg REV.C DD 10.02.22 verified by:EC IPP rev C 11.05.24 ECN
11-578 ec verified by:DD IPP REV:D 11.08.16 AS PER
REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3954-5

Manufactured No

100

Each

5.0000

1

2

D3954-5

Chain Lug

**

OK 17/09/06

Location

Loc Qty

Loc Code

WA002 162334
109239

5

5

2

D3954-9

Manufactured No

100

Each

8.0000

1

2

D3954-9

Gwt Chain Pin

**

OK 17/09/06

Location

Loc Qty

Loc Code

WA
149709

1

1

WA001
114386

2

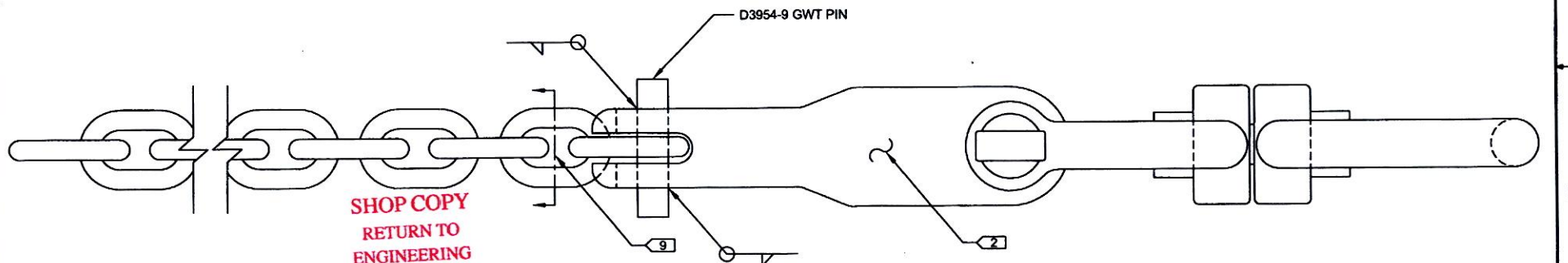
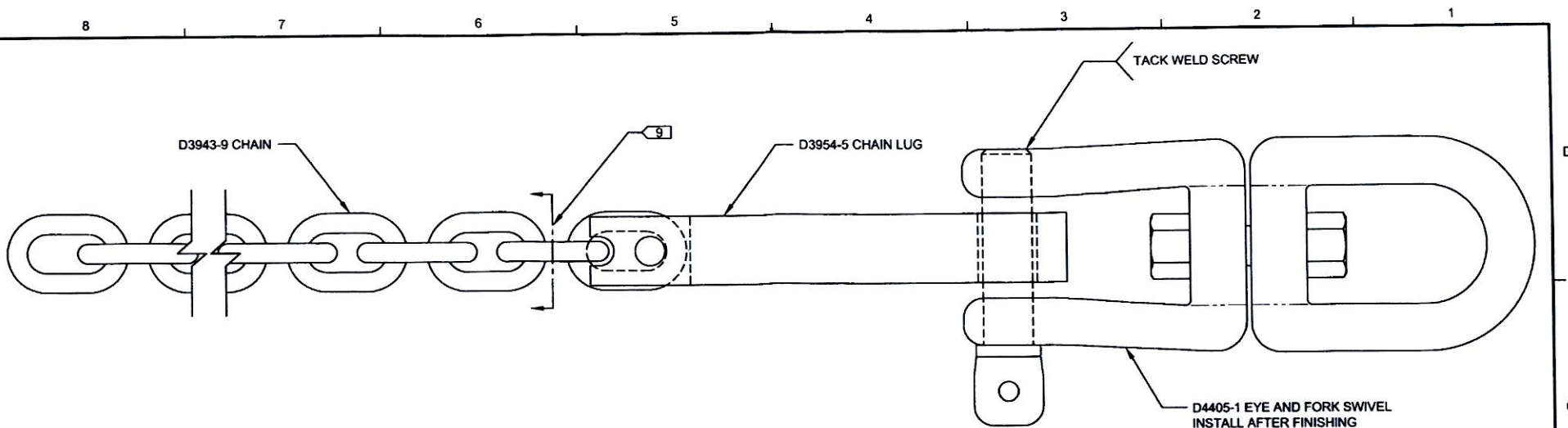
2

WA002
155190

5

5

23



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158970 MJS
170405

D3943-053 CHAIN ASSEMBLY

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO FINISHING

RELEASED
2011-07-29
MD

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	